CLAIMS

1. A method of forming a tube, comprising:

unwrapping the tube from a feed roll to create an unwrapped section of tube extending from a first point to a second point of the tube with the feed roll being closer to the first point than the second point; and

simultaneously bending the tube at the second point and at an intermediate point interposed between the first point and the second point while unwrapping the tube from the feed roll.

2. The method of claim 1, further comprising wrapping a heat conductive member around the tube at a location between the first point and the intermediate point.

3. The method of claim 1, further comprising forming the tube into a serpentine shape.

4. The method of claim 1, further comprising moving the intermediate point more than the second point while bending the tube.

5. The method of claim 1, further comprising rotating the intermediate point about the second point.

6. The method of claim 1, further comprising applying tension to the tube between the intermediate point and the second point.

7. A method of forming a tube into a heat exchanger, comprising:

unwrapping the tube from a feed roll to create an unwrapped section of tube;

wrapping a heat conductive member around the unwrapped section of tube; and

bending the unwrapped section of tube while simultaneously unwrapping the tube and wrapping the heat conductive member.

8. The method of claim 7, further comprising creating an unwrapped section of tube extending from a first point to a second point of the tube with the feed roll being closer to the first point than the second point; and simultaneously bending the tube at the second point and at an intermediate point interposed between the first point and the second point.

9. The method of claim 8, further comprising wrapping the heat conductive member around the tube at a location between the first point and the intermediate point.

10. The method of claim 7, further comprising forming the tube into a serpentine shape.

11. The method of claim 8, further comprising moving the intermediate point more than the second point while bending the tube.

12. The method of claim 8, further comprising rotating the intermediate point about the second point.

13. The method of claim 8, further comprising applying tension to the tube between the intermediate point and the second point.

14. A tube bender adapted to bend a tube into a serpentine shape, comprising:

a frame having a tube-receiving end adapted to receive the tube, a support structure adapted to support the serpentine shape, and a bending region interposed between the tube-receiving end and the support structure;

a first anchor supported by the frame and being adapted to engage the tube;

a second anchor supported by the frame and being adapted to engage the tube, wherein the first anchor and the second anchor are spaced apart from each other and are closer to the support structure than the tube-receiving end;

a first die adapted to engage the tube in the bending region and being moveable relative to the frame to bend the tube about the first anchor; and

a second die adapted to engage the tube in the bending region and being moveable relative to the frame to bend the tube about the second anchor.

15. The tube bender of claim 14, wherein the first anchor is moveable between an extended position to engage the tube and a release position to disengage the tube.

16. The tube bender of claim 14, wherein movement of the first die and the second die is out of phase to each other.

17. The tube bender of claim 14, further comprising a first rotating member; a second rotating member; a third die adapted to engage the tube in the bending region and being moveable relative to the frame to bend the tube about the first anchor; and a fourth die adapted to engage the tube in the bending region and being moveable relative to the frame to bend the tube about the second anchor, wherein the first die and the third die are attached to the first rotating member, and the second die and the fourth die are attached to the second rotating member.

18. The tube bender of claim 17, wherein the first die, the second die, the third die and the fourth die are adapted to engage the tube sequentially as the first rotating member and the second rotating member rotate.

19. The tube bender of claim 17, wherein the first rotating member and the second rotating member rotate substantially 90-degrees out of phase relative to each other.

20. The tube bender of claim 14, further comprising a feed roll adapted to pay out the tube toward tube-receiving end of the frame.

21. The tube bender of claim 20, further comprising a spine fin wrapper interposed between the feed roll and the tube-receiving end of the frame, wherein the spine fin wrapper is adapted to wrap a heat conductive member around the tube.

22. The tube bender of claim 14, wherein the first die is further moveable between an operative position and a retracted position, wherein the operative position allows the first die to engage the tube and the retracted position allows the first die to travel past the tube.

23. The tube bender of claim 22, further comprising a cam surface associated with the first die, wherein the first die moves between the operative position and the retracted position in response to the die moving relative to the cam surface.

24. The tube bender of claim 22, further comprising a spring that urges the first die to the retracted position.